

Date: Monday, 2/11/2008 11:38:48 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 CARGO MIRROR  
Job Number : 37316  
Estimate Number : 10095  
P.O. Number :  
This Issue : 2/11/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D044715011  
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3243REV A  
Previous Run : 36024 Material : Manufacture in multiples of 10  
Written By : Due Date : 2/25/2008 Qty: Um: Each  
Checked & Approved By :  
Comment : Est Rev:A 04.02.18 New issue KJ/JLM  
Est Rev:B 06-04-28 Manufactured on Water Jet JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011 CHG001

08.02.12

2.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.5359 sf(s)/Unit Total : 2.6796 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: 165225 B 8-2-11

3.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: A

Prog Rev: A

B 8-2-11

(6)

2-Deburr if necessary

B 8-2-11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-2-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/02/12 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

SP 08/03/13

(6)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/03/14 (6)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

M-J

08/03/17

(6X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08/03/24

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 FE-032EF

Insert

M105385

x 24

1 D3243-1(Ref)

Bracket

B37316

x 6

ml 08/03/24 x6

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

ml 08/03/24 x6

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/24 (6)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-J

08/03/26

(6X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 37316

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-26 (X6)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

2 D1048

Clamp

30373 5X

35037 7X

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

2 D1049

Saddle

32777

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

1 D2010-104

Arm

37722

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

1 D2011-101

Mirror

35836 1X 37326 5X

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

4 ALS4-1032-130Insert

105854

PC 8/3/27 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:

Machine Or Operation:

Description :

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A

Bolt

M153641

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10 Screw

15672

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L Washer

M104885

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location: Rev A

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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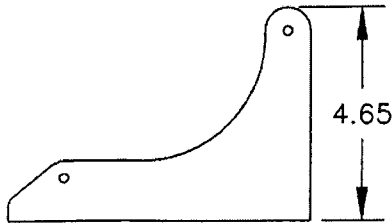
NOTE: Date & initial all entries







DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/  
D3243-041 ASSEMBLY  
SCALE 1:4

INSTALL  
FE-032-EF INSERTS  
(4 PLACES)

2.75  $\pm 0.030$   
0.000

11.920

11.420

Ø0.201  
(TYP 4  
PLACES)

Ø0.290  
(TYP 4  
PLACES)

1.375

5.273

3.714

0.500

0.000

8.581

8.206

7.706

4.214

3.339

R0.38  
(TYP)

5.494

6.560

5.810

5.360

GRAIN  
DIRECTION

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 37316

R2.75  
(TYP)

D3243-1  
FLAT PATTERN

R0.50  
(TYP)

0.750  
0.500  
0.000

RELEASED  
04.02.03

**D3243-041 BRACKET ASSEMBLY  
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK  
(QQ-A-250/11, REF DART SPEC  
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO  
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

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